

Work Order ID 102280-2

May-27-13 3:55:07 PM

Run *EMILIE* 03278-041 *PLEASE*
102280

Page 1

Item ID: D2230-1

Revision ID:

Item Name: Lug

Start Date: 6/03/13

Required Date: 6/03/13

Reference:

Start Qty: 220.00

Req'd Qty: 220.00

SPUT
84
220
220

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: *MLS*

Date: *13-05-27*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2230

Rev G

110

Outsource process - Machining

0.00

110

Outsource5

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

Outsource process - Machining

Issue P/O to Metec: *P020001*

Machine as per dwg

C of C is required

2
WHS 5/24/20

120

Receive & Inspect for Damage & Mat'l Certs

0.00

120

Packaging

Memo

0.00

Packaging

Ensure C of C is attach

7/3/13 (84)

130

QC6- Inspect dimensions to drawing

0.00

130

QC

Memo

0.00

Quality Control

SWP
13614

SG

Work Order ID 102280

102280

Page 2

Item ID: D2230-1

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Lug

Start Date: 6/03/13

Start Qty: 220.00

220

Cust Item ID:

Required Date: 6/03/13

Req'd Qty: 220.00

220

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

86 25136-17

150

QC - Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

86x Ø m/f 13/06/17

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

160

Powdercoat

Memo

0.00

Powder Coating

START TIME:
OVEN TEMPERATURE:
FINISH TIME:

2:00
320°F
2:30

86x Ø m/f 13/06/17

m125620

Work Order ID 102280

May-27-13 12:42:48 PM

102280

Page 3

Item ID: D2230-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Lug

Start Date: 6/03/13

Start Qty: 220.00

220

Cust Item ID:

Required Date: 6/03/13

Req'd Qty: 220.00

220

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

86 x 6 13/06/13

180

Identify as per dwg & Stock Location: ST469

0.00

180

Packaging

Memo

80x = G-A

0.00

Packaging

SP

6x

11.10.13-06-20 SP

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

13/6/25

13-06-24

Picklist Print

May-27-13 12:42:48 PM

Page 1

Work Order ID: 102280
Parent Item: D2230-1
Parent Item Name: Lug

Start Date: 6/03/13
Start Qty: 220.00

Required Date: 6/03/13
Required Qty: 220.00

Comments: IPP D00.11.01Added inspection level 8, and removed P/O for powder coatEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-1P LUG		Purchased	No				Each	0.0000		220			
D2423 Lug Extrusion		Manufactured	No			110	f	566.7400	0.0683	15.816834			

Location

Loc Qty

Loc Code

MAT006

383

43722

161.5

87953

221.5

Metec

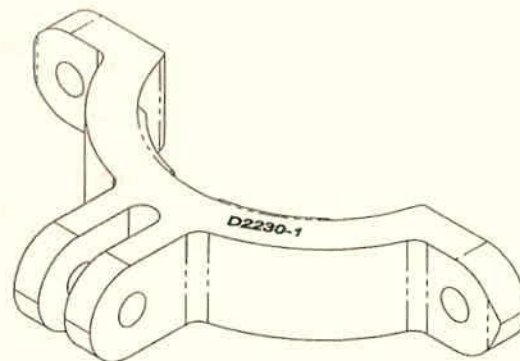
183.74

93551

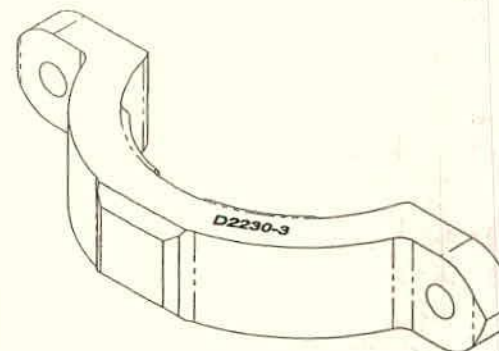
183.74

15.8168

9/3/13 (80)
C/L 13/05/29



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

102280 MLJ
1305-27

RELEASED
01/06/15



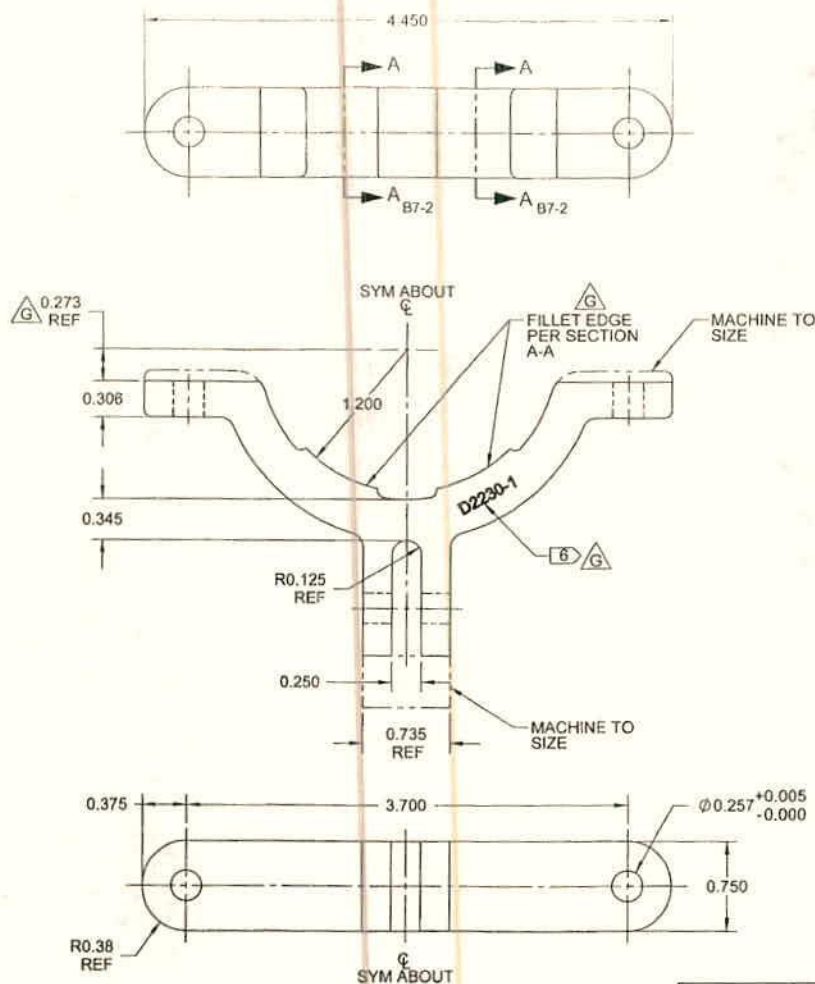
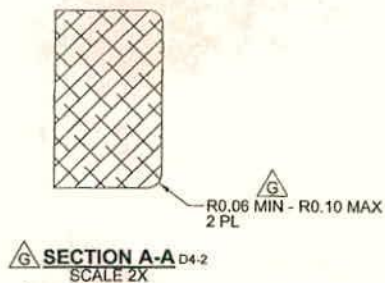
NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN, R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN		BW	
DRAWN		AJS	
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.16		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2230	REV. G SHEET 1 OF 3
TITLE MOUNTING LUG	SCALE NTS
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10.228



D2230-1 MOUNTING LUG

RELEASED
09/06/75

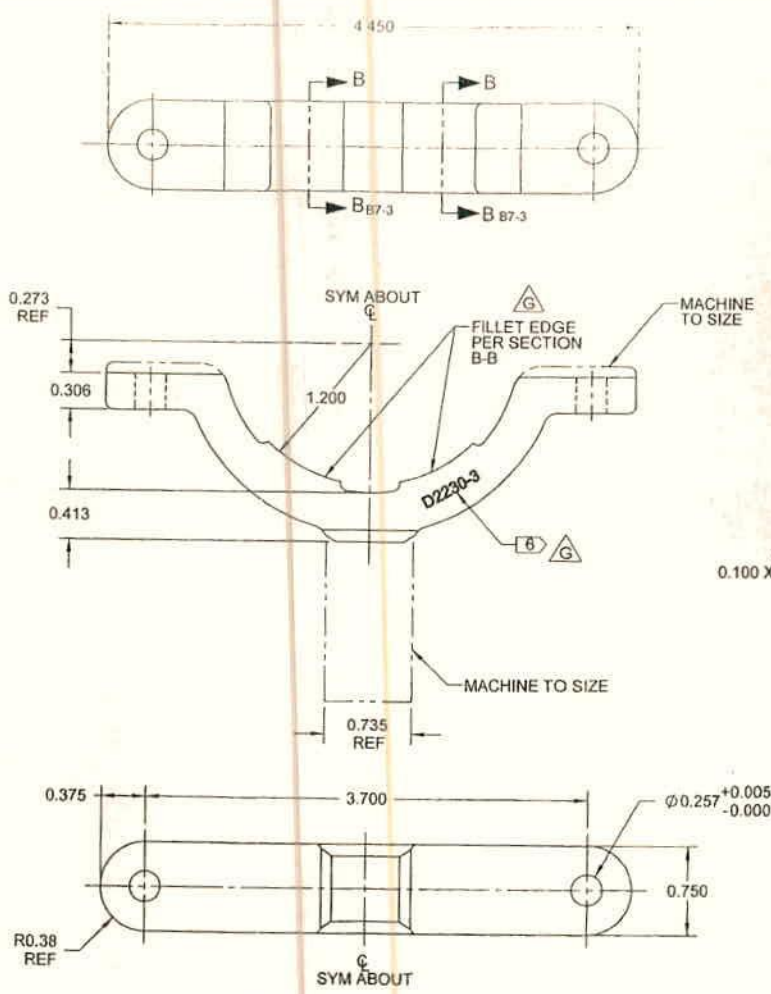
DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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102280

SECTION B-B
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

RELEASED
09/06/2016

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, CN K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO20001**

Purchase Order Date 5/28/2013

PO Print Date 5/28/2013

Page Number 1 of 1

er From :
IETEC METAL TECHNOLOGY INC.
10 TERRY FOX DRIVE PO BOX 781
ANKLEEK HILL, ON K0B 1R0
A

VC-MET003

Contact Name
Vendor Phone 613 678 3957
Vendor Fax 613 678 3956
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 10
Currency CAD
FOB Destination-Collect

To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
05/28/13

e Nbr	Reference Revision ID	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
D2230-1P		LUG	6/11/2013 Yes	220.00 Each	Dart Truck	\$18.9500	\$4,169.00

Specs: Inst: MACHINE AS PER DWG, FOR D2230
REV.G
BATCH# 102280

Rec 86
6/3/13

PO Total: \$4,169.00

Change Nbr: 1

Change Date: 5/28/2013

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required - **YES** NO



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 19071
Date: Jun 13, 2013
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 20001	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date: Jun 13, 2013

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug Machine as per drawing for D2230 REV.G Batch#102280	Each	220	86	134
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
86	D2230-1	Lug	PO 20001

MATERIAL: supplied by DART B93551

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, June 13, 2013